

# Work Order ID 58103



Page 1

April 23, 2010 9:06:24 AM

Item ID: D350-636-012

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 4/23/10 Start Qty: 1.00



Cust Item ID:

Required Date: 4/30/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

0.00

100



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 005

5/10/05

HJ for BG 10/05/05

358103

# Work Order ID 58103

April 23, 2010 9:06:24 AM



Page 2

Item ID: D350-636-012

Accept



Setup Start



Revision ID:

Item Name: Skidtube RH

Stop



Start Date: 4/23/10 Start Qty: 1.00



Cust Item ID:

Required Date: 4/30/10 Req'd Qty: 1.00



Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 5 (D2750-2 details).Drill using drill Jig DT8150 & DT8863 .

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750. Deburr.

4- Drill fwd step holes using DT9616. Ensure proper positioning.

5-Drill pilot holes for blade fitting bolts using DT8983. Open to 0.500"

6- locate DT8329 off of blade fitting bolt holes and drill pilot holes blade fitting.

7-Open up holes for Detail K to 0.375" (4 holes per side) blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail L to 0.500" (8 holes per side)

8-Drill pilot holes for wearplates as per Dwg D2750 using DT8108. Open to 0.297".

9-Open up holes of Detail J to 0.297" (total of 2 holes per side)

10-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R: Aluminum Rod

Batch:

M113207

BB

10/04/27

110/41/27

**Work Order ID 58103**

April 23, 2010 9:06:30 AM

Page 3



Item ID: D350-636-012

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Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 4/23/10 Start Qty: 1.00



Cust Item ID:

Required Date: 4/30/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

11-Grind welds flush as per Dwg D2750

H 10/4/27

12- scribe batch #.

H 10/4/27

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

S 10/4/27

Memo

0.00

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 10/4/27

Memo

0.00

⑦

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 58103**

April 23, 2010 9:06:30 AM



Page 4

Item ID: D350-636-012

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Setup Start



Revision ID:

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Item Name: Skidtube RH

Start Date: 4/23/10 Start Qty: 1.00



Cust Item ID:

Required Date: 4/30/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
 HandFinish	Memo	0.00							
Hand Finishing									
150	QC3- Inspect Part Finish	0.00							
 QC	Memo	0.00							
Quality Control									

1 11/01/4/27

① 8E10/04/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 58103

April 23, 2010 9:06:34 AM



Page 5

Item ID: D350-636-012

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Revision ID:

Item Name: Skidtube RH

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Start Date: 4/23/10 Start Qty: 1.00



Cust Item ID:

Required Date: 4/30/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Skidtubes	Skidtubes	0.00							
Skidtubes	<b>Memo</b> 1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750. 3-Open float holes to .500" (4 per Side) 4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9) 5-Deburr and blow out all chips from inside of tube 6-Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015 A/R: 11 Sikaflex-291 batch: <u>M112429</u> exp. date: <u>10/3/30</u> 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R: 1 Aluminum Rod batch: <u>M113207</u> 9- At section AP-AP drill out x-bolt spacer to 0.404" 10-Grind welds flush as per Dwg D2750 11-Spot face ground handling holes section (total of 4 places per side) as per	0.00							

M 10/4/27

BE 10/04/28  
BE 10/04/28

BE 10/04/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



**Work Order ID 58103**

April 23, 2010 9:06:40 AM

Page 6



Item ID: D350-636-012

Accept



Setup Start



Revision ID:

Item Name: Skidtube RH

Stop



Start Date: 4/23/10 Start Qty: 1.00



Cust Item ID:

Required Date: 4/30/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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dwg D2750

12-Deburr holes

BE 10/04/29

170

QC10- Inspect visual per QSI004- ground welds

0.00

8/10/04/30



QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

8/10/04/30



QC

Memo

0.00

Quality Control

④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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April 23, 2010 9:06:40 AM

Page 7

Item ID: D350-636-012

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Setup Start

Revision ID:

Item Name: Skidtube RH

Stop

Start Date: 4/23/10 Start Qty: 1.00

Cust Item ID:

Required Date: 4/30/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

Pressure Wash per QSI005 4.3

0.00

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

=> m-d 10/05/03

(IX)

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:45am  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 1:15pm

=> m-d 10/05/03

1 X

210

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

=> m-d 10/05/04

(IX)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 58103**

April 23, 2010 9:06:41 AM

Page 8



Item ID: D350-636-012

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Setup Start



Revision ID:

Item Name: Skidtube RH

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Start Date: 4/23/10 Start Qty: 1.00



Cust Item ID:

Required Date: 4/30/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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220

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

Install inserts as per dwg D2750

= 7 m-k 10/05/04

(IX)

230

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"  
batch: N/A3-Install blade fitting D3488-042, wearshoes and ground handling hardware as  
per dwg D2750

SIKA FLEX 241

BATCH:

EXP DATE:

M112429  
10/084-assemble o'ring to plug as per dwg D3492 and apply o'ring lube  
A/R 55-o'ring lube batch: M1141895-Coat all exposed fasteners with "LPS Procyon"  
batch: M1104251

m-k 10/05/04

(IX)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 58103**

April 23, 2010 9:06:46 AM

Page 9

Item ID: D350-636-012

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Setup Start

Revision ID:

Item Name: Skidtube RH

Stop

Start Date: 4/23/10 Start Qty: 1.00

Required Date: 4/30/10 Req'd Qty: 1.00

Cust Item ID:

Customer:




Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00	8 10/05/04			(41)			
250  Packaging Packaging	Pick Kit  Memo	0.00 0.00							10-0-0 5
260  QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00 0.00	8 10/05/06			(40)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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April 23, 2010 9:06:46 AM

Page 10

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Required Date: 4/30/10 Req'd Qty: 1.00



Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	Packaging	0.00							
									
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-012								
280	QC21- Final Inspection - Work Order Release	0.00							
									
QC	Memo	0.00							
Quality Control									

10/05/07  
mf 10-5-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

April 23, 2010 9:05:43 AM

Page 1

Work Order ID: 58103

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps [KJ]  
 IPP Rev: J 06-03-29 As per Rev D EC  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 4/23/10

Required Date: 4/30/10

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

220

Each

7,579.000 38.0000



Insert

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

PK011

7579

110768 ✓

7579

AN3C5A

Purchased

No

230

Each

807.0000 34.0000



Bolt

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST350

500

114330 ✓

500

Main Warehouse

ST351

307

113121

53

114056

103

114108

51

114181

100

10/05/04

38 x m-k

34 x m-k 10/05/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

April 23, 2010 9:05:44 AM

Work Order ID: 58103



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 4/23/10

Required Date: 4/30/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ

Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-29 As per Rev D EC

IPP Rev: K 06-07.13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

AN3C6A

Purchased

No

230

Each

647.0000

4.0000



BOLT

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST351

647

111982 ✓

647

AN6C44A

Purchased

No

230

Each

95.0000

4.0000



BOLT

## Warehouse

## Loc Qty

## Loc Code

### Location

OFFSHORE

FG

2

103964

2

Main Warehouse

ST344

93

111649 ✓

43

114455

50

10/05/04

4X m-d

10/05/04

4X m-d

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 58103



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 4/23/10

Required Date: 4/30/10

Comments:

IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-29 As per Rev D EC  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

95.0000

2.0000



BOLT

10-5-4 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST345

95

111605

45

113558

50

AN8C35A

Purchased

No

230

Each

67.0000

1.0000



BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

17

110847

17

Main Warehouse

ST346

50

114442

50

AN960C10L

Purchased

No

230

Each

0.0000

38.0000



washer

NA S1149C0332R

M114341

10/05/04  
1X m-k

38 m-k  
10/05/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

April 23, 2010 9:05:45 AM

Page 4

Work Order ID: 58103



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 4/23/10

Required Date: 4/30/10

Comments: IPP Rev: I102.09.25 Rearranged procedure steps KJL  
 IPP Rev: J 06-03-29 As per Rev D EC  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

AN960C816L

Purchased No

230

Each

140.0000

1.0000



WASHER

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST348

140

110584

100

111424

40

AN960C816L

Purchased No

250

Each

140.0000

2.0000



WASHER

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST348

140

110584

100

111424

40

D2741

Manufactured No

250

Each

41.0000

1.0000



Blade, 350 Skidtube

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST466

41

51931

9

55905

32

10/05/04

IX m-h

10-5-5

2  
10-5-5

April 23, 2010 9:05:45 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

April 23, 2010 9:05:45 AM

Work Order ID: 58103



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 4/23/10

Required Date: 4/30/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps [KJ]  
 IPP Rev: J 06-03-29 As per Rev D EC  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D2745 Manufactured No 230 Each 134.0000 8.0000



Bushing

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse	B 57914	
ST023	134	
52311	134	

8x m-l  
 10/05/04

D3488-042 Manufactured No 230 Each 26.0000 1.0000



Blade Fitting Assembly, RH

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	6	
52666	6	
Main Warehouse		
FP008	20	
53918 ✓	20	

1x m-l  
 10/05/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

April 23, 2010 9:05:46 AM

Work Order ID: 58103



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 4/23/10

Required Date: 4/30/10

Comments: IPP Rev: H 02.09.25 Rearranged procedure steps [KJ]  
 IPP Rev: J 06-03-29 As per Rev D EC  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3492-041 Manufactured No 230 Each 66.0000 8.0000



Plug Assembly



Warehouse Loc Qty Loc Code

Location

Main Warehouse

B 57915

FP 26

55446 26

Main Warehouse

FP031 40

57517 40

8x m-k  
10/05/04

D3492-043 Manufactured No 230 Each 66.0000 8.0000



Plug Assembly



Warehouse Loc Qty Loc Code

Location

Main Warehouse

B 57916

FP 26

54682 26

Main Warehouse

FP013 40

57519 40

8x m-k \*  
10/05/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 7

April 23, 2010 9:05:46 AM

Work Order ID: 58103



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 4/23/10

Required Date: 4/30/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ

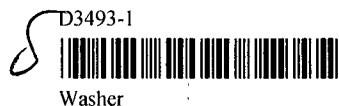
Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-29 As per Rev D EC

IPP Rev: K 06-07.13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC



D3493-1 Manufactured No 250 Each 55.0000 2.0000



10-5-5

Warehouse  
Location

Main Warehouse

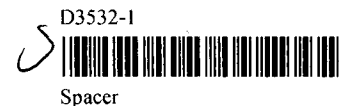
ST065 40

57825 40

Main Warehouse

ST224 15

47710 15



D3532-1 Manufactured No 250 Each 47.0000 2.0000



10-5-5

Warehouse  
Location

Main Warehouse

ST068 47

52321 47

April 23, 2010 9:05:47 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

April 23, 2010 9:05:48 AM

Page 8

Work Order ID: 58103



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 4/23/10

Required Date: 4/30/10

Comments: IPP Rev: I 102.09.25 (Rearranged procedure steps) [KJL]

Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-29 As per Rev D EC

IPP Rev: K 06-07.13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

D3535-25

Manufactured No

230

Each

13.0000

1.0000



Wearshoe

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

FP

13

56065

1

56839 ✓

12

D3536-25

Manufactured No

230

Each

7.0000

1.0000



Gasket

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

FP10

7

54479

7

B57944

1X m-l

10/05/04

April 23, 2010 9:05:48 AM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 9

April 23, 2010 9:06:00 AM

Work Order ID: 58103



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 4/23/10

Required Date: 4/30/10

Comments:

IPP Rev: I 02.09.25 Rearranged procedure steps KJ

Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-29 As per Rev D EC

IPP Rev: K 06-07.13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

D3537-1

Manufactured No

230

Each

40.0000

3.0000



Wearpad

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

FP

55465

Main Warehouse

FP17

57510

B 57511

9

9

31

31

3x m.k.  
10/05/04

D3631-1

Manufactured No

230

Each

286.0000

8.0000



Washer

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST076

52693

286

286

8x m.k.  
10/05/04

April 23, 2010 9:06:01 AM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

April 23, 2010 9:06:01 AM

Work Order ID: 58103



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 4/23/10

Required Date: 4/30/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ

Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-29 As per Rev D EC

IPP Rev: K 06-07.13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

D3672-1 Manufactured No 230 Each 1,547.000 4.0000



Phenolic Washer

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST077 1547

47628 47

51674 500

52505 1000

D3672-13 Purchased No 250 Each 916.0000 2.0000



Phenolic Washer

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST077 916

54363 916

m-h  
4x  
10/95/04  
10-5-5 SP

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

April 23, 2010 9:06:06 AM

Page 11

Work Order ID: 58103



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 4/23/10

Required Date: 4/30/10

Comments:

IPP Rev: I 02.09.25 Rearranged procedure steps KJ

Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-29 As per Rev D EC

IPP Rev: K 06-07-13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

D3791-1

Manufactured No

230

Each

16.0000

1.0000



Wearplate

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

FP

5

55457 ✓

5

Main Warehouse

FP17

11

56299

11

D3793-1

Manufactured No

230

Each

12.0000

1.0000



Wearshoe

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

FP18

12

56300 ✓

12

D3793-3

Manufactured No

230

Each

8.0000

1.0000



Wearshoe

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

FP19

8

55458

8

April 23, 2010 9:06:06 AM

Shop Packet Print

Page 11

1x m-k 10/05/04

1x m-k 10/05/04

B 57947

1x m-k 10/05/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

April 23, 2010 9:06:06 AM

Work Order ID: 58103



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 4/23/10

Required Date: 4/30/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps [KJ]  
 IPP Rev: J 06-03-29 As per Rev D EC  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3794-1 Manufactured No 230 Each 17.0000 1.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	5	
55459	5	
Main Warehouse		
FP014	12	
57537 ✓	12	

10/05/04  
 1X m-l

D3794-3 Manufactured No 230 Each 25.0000 1.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	2	
51907	2	
Main Warehouse		
FP18	23	
56066 ✓	23	

10/05/04  
 1X m-l

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

April 23, 2010 9:06:12 AM

Work Order ID: 58103



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 4/23/10

Required Date: 4/30/10

Comments: IPP Rev: J 02.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-29 As per Rev D EC  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

MS21043-6 Purchased No 230 Each 870.0000 4.0000



NUT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST301

870

112314 ✓

870

MS21083C8 Purchased No 230 Each 44.0000 1.0000



NUT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST303

44

113845 ✓

44

MS21083C8 Purchased No 250 Each 44.0000 2.0000



NUT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST303

44

113845 ✓

44

10/05/04

4x m-l

10/05/04

1x m-l

10-5-5 sf

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

April 23, 2010 9:06:12 AM

Page 14

Work Order ID: 58103



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 4/23/10

Required Date: 4/30/10

Comments:

IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-29 As per Rev D EC  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased No

230

Each

330.0000

8.0000



O-RING

D259-3

B58191

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

FP

330

110715

100

110915

230

NAS1611-013

Purchased No

230

Each

234.0000

8.0000



O-RING

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

FP

234

113743

25

114451

209

D2600-3-BENT

Manufactured No

110

Each

4.0000

1.0000



Extrusion Bent

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

LG

4

55462

2

57538

2

April 23, 2010 9:06:12 AM

Shop Packet Print

Page 14

8X m-h  
 10/05/04  
 PRO →

8X m-h  
 10/05/04

1 10/4/27

W/O: 58103		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/05/04	230	CHANGE FOR O'RING D0544-3 BS 8191	m-h	10/05/04	8		S 10/05/04

Part No: D350-636-012 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

April 23, 2010 9:06:18 AM

Work Order ID: 58103



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 4/23/10

Required Date: 4/30/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-29 As per Rev D EC  
 IPP Rev: K 06-07-13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D2744 Manufactured No 110 Each 31.0000 1.0000



Cap

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	31	
47488	13	
51922	18	

1 11/10/27

D2739 Manufactured No 160 Each 3.0000 1.0000



350 I Beam

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	3	
56060	3	

B 57948 D 11/10/27

D2743 Manufactured No 160 Each 98.0000 8.0000



Crossbolt Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	98	
50281	50	
52310	48	

8 BE 10/10/28

# Picklist Print

Page 16

April 23, 2010 9:06:18 AM

Work Order ID: 58103



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 4/23/10

Required Date: 4/30/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-29 As per Rev D EC  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3490-3 Manufactured No 160 Each 23.0000 4.0000



Cross Bolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

55010

B 57918 (x4)

23

23

BE 10/04/29

D3490-1 Manufactured No 160 Each 57.0000 4.0000



Cross Bolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

57723

57

57

x4 BE 10/04/28

April 23, 2010 9:06:18 AM

Shop Packet Print

Page 16



QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

# **GENERAL NOTES:**

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H3L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC.	
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MFG. APPR.		D2750	SHEET 1 OF 11
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62 07 22 14

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58103

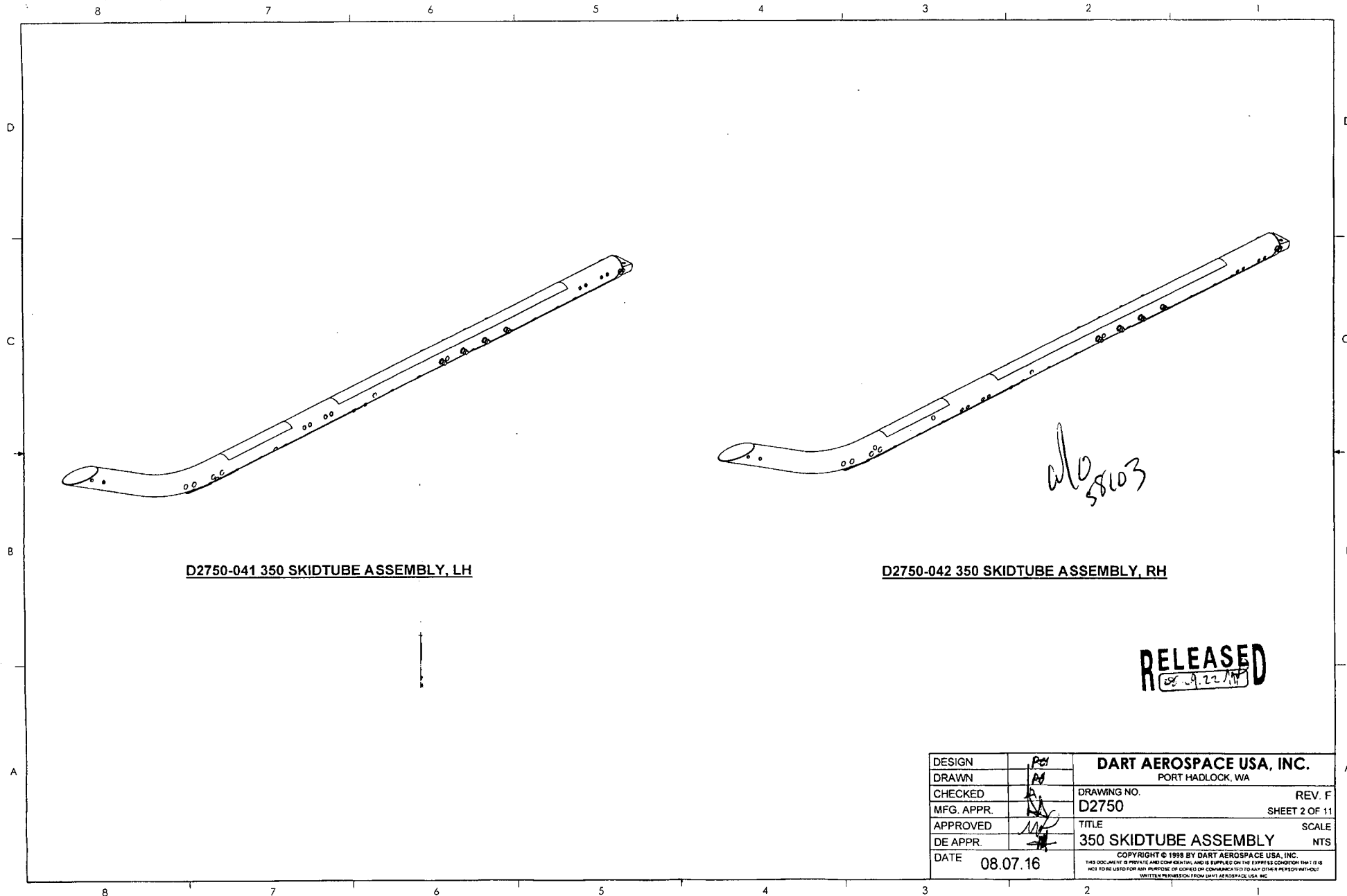
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



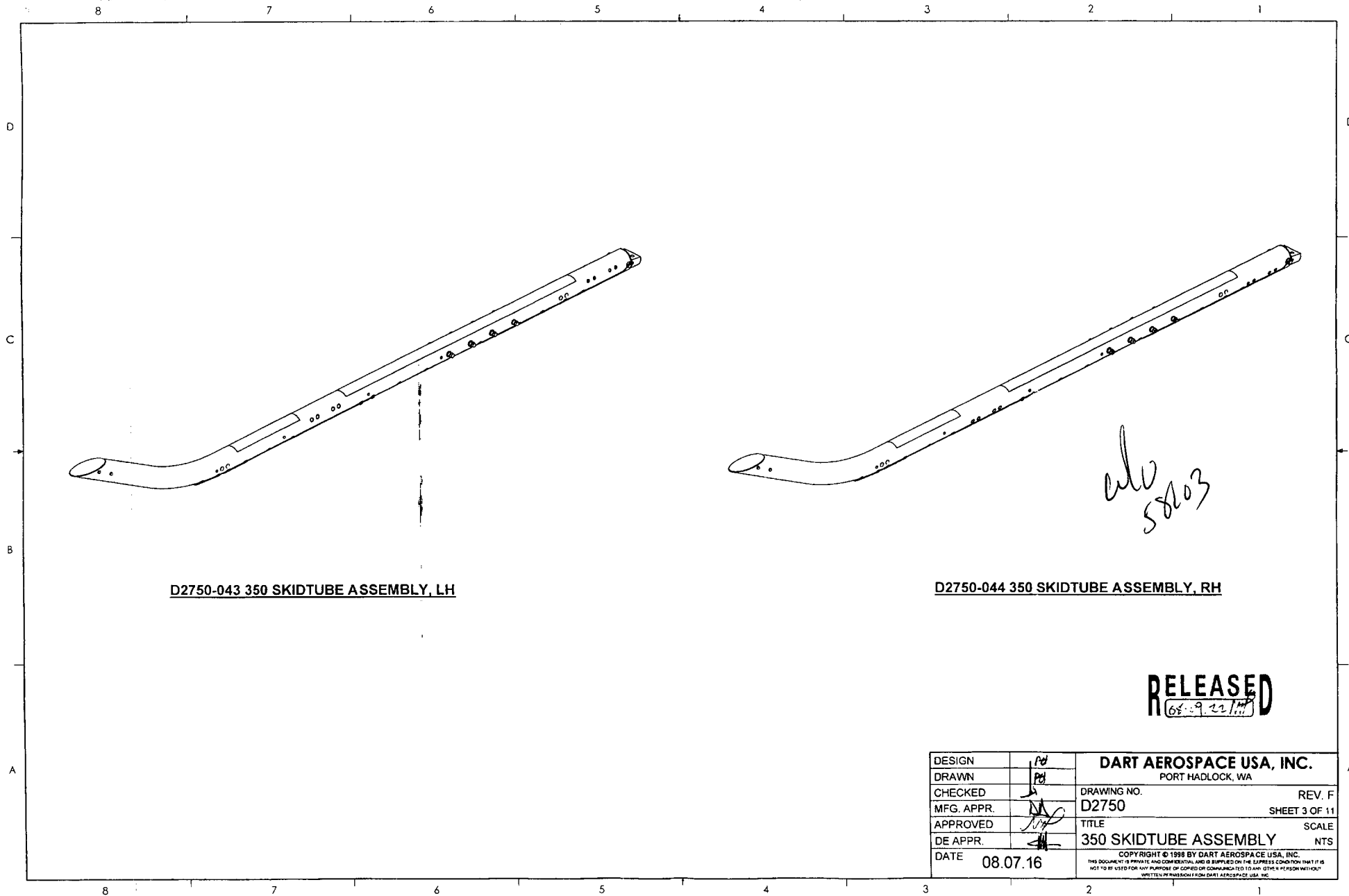
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D2750-043 350 SKIDTUBE ASSEMBLY, LH

D2750-044 350 SKIDTUBE ASSEMBLY, RH

*alt  
58003*

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68-09-22/144

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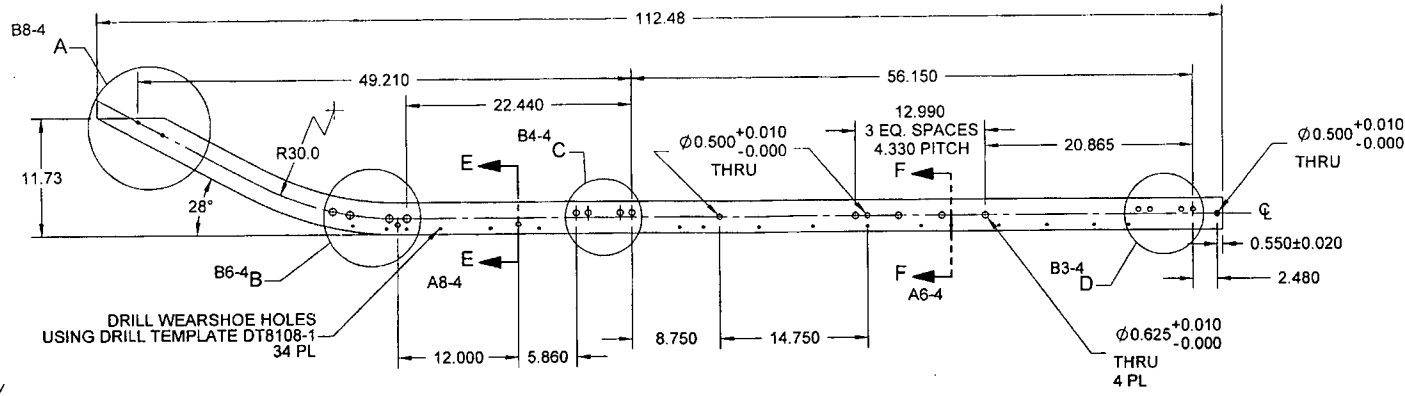
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng./ Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

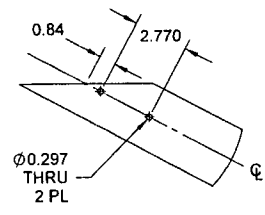
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

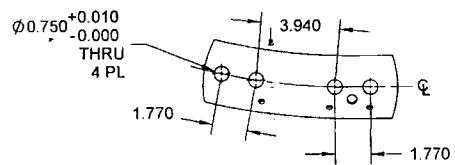
**NOTE:** Date & initial all entries



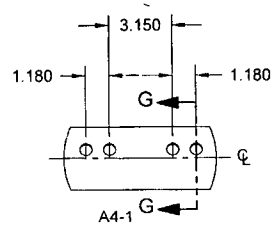
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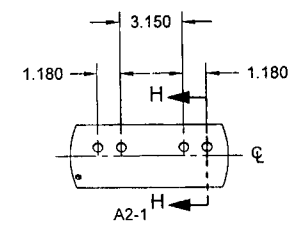
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SCALE 2X



**DETAIL B**  
SCALE 2X



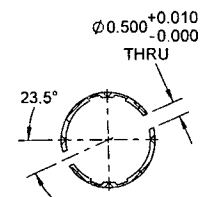
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SCALE 2X



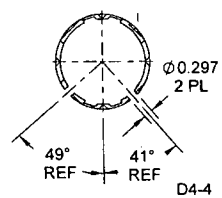
**DETAIL D**  
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*also 58003*

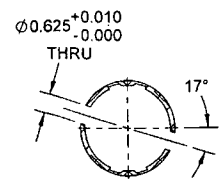
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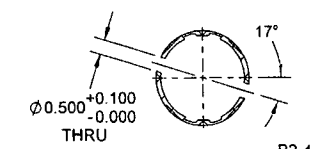
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL

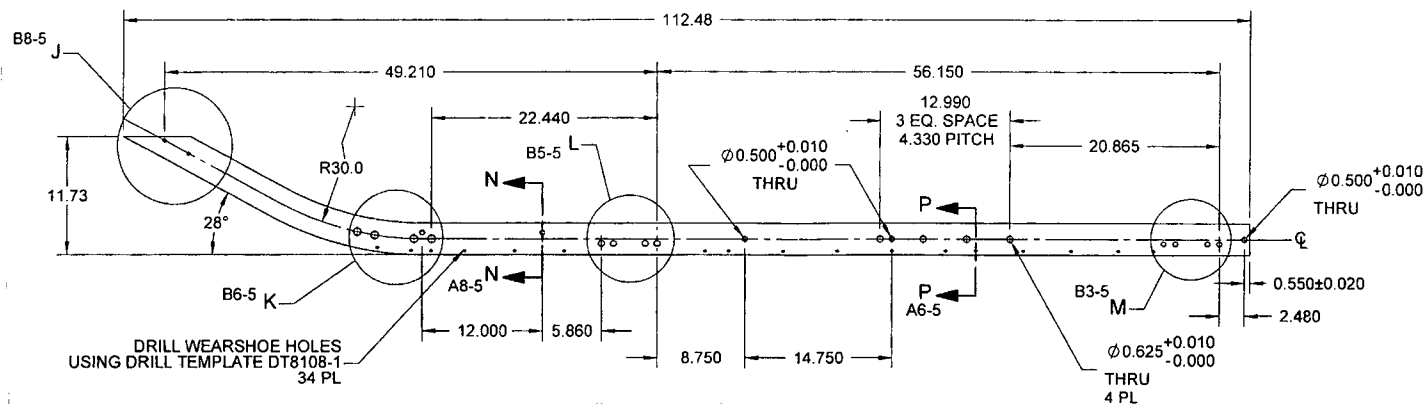


**SECTION G-G**  
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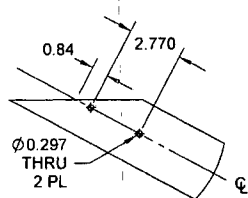


**SECTION H-H**  
SCALE 3X, 4 PL

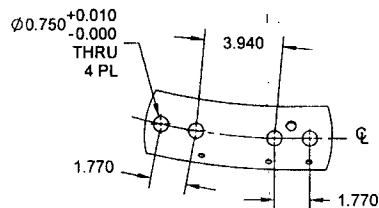
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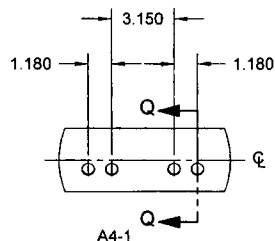
**D2750-2 RH SKIDTUBE**



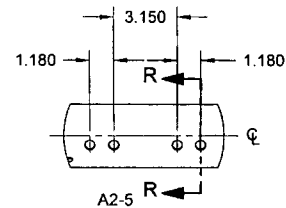
**DETAIL J**  
SCALE 2X



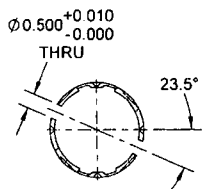
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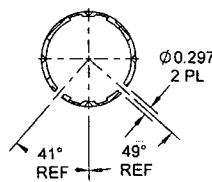
**DETAIL L**  
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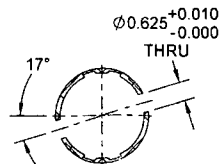
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SCALE 2X



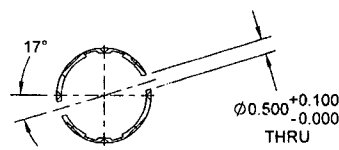
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



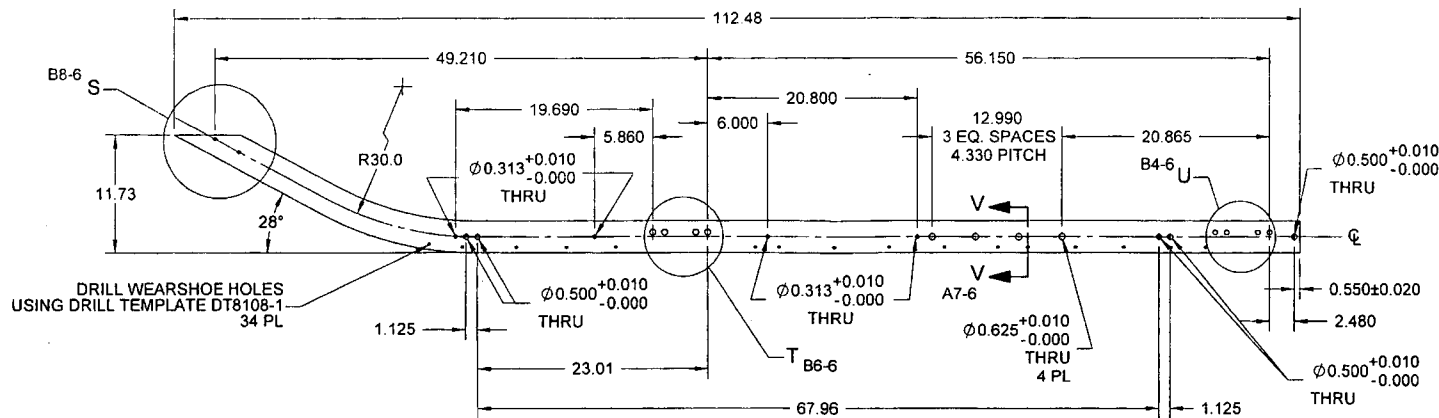
**SECTION R-R**  
SCALE 3X, 4 PL

*Wb 58103*

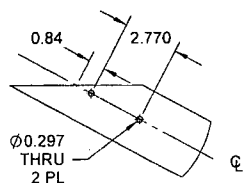
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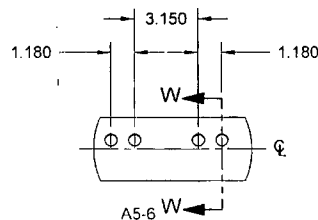




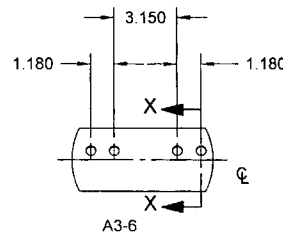
**D2750-3 LH SKIDTUBE**



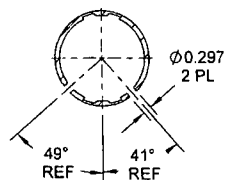
**DETAIL S**  
SCALE 2X



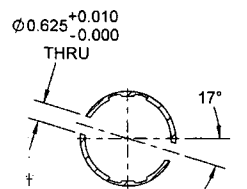
**DETAIL T**  
SCALE 2X



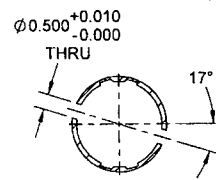
**DETAIL U**  
SCALE 2X



**SECTION V-V**  
SCALE 3X, 17 PL



**SECTION W-W**  
SCALE 3X, 4 PL

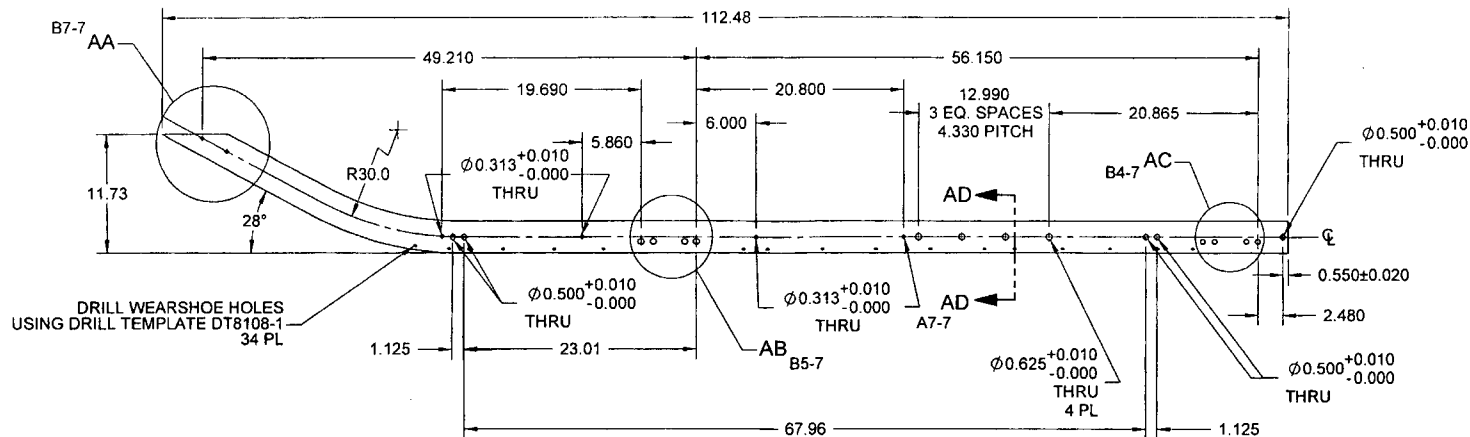


**SECTION X-X**  
SCALE 3X, 4 PL

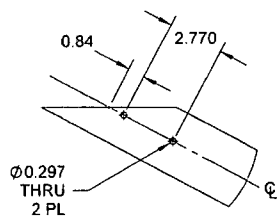
*WLO 58103*

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08 07 16

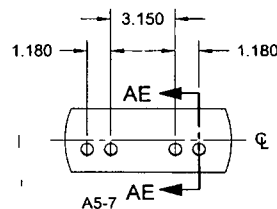
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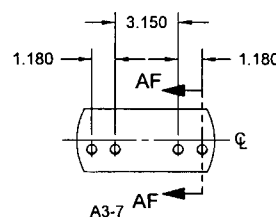
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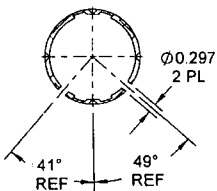
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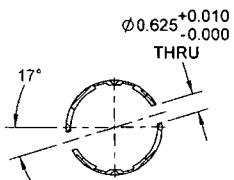
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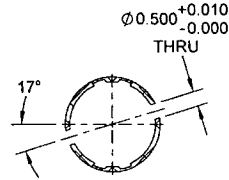
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL









**SECTION AE-AE**  
SCALE 3X, 4 PL

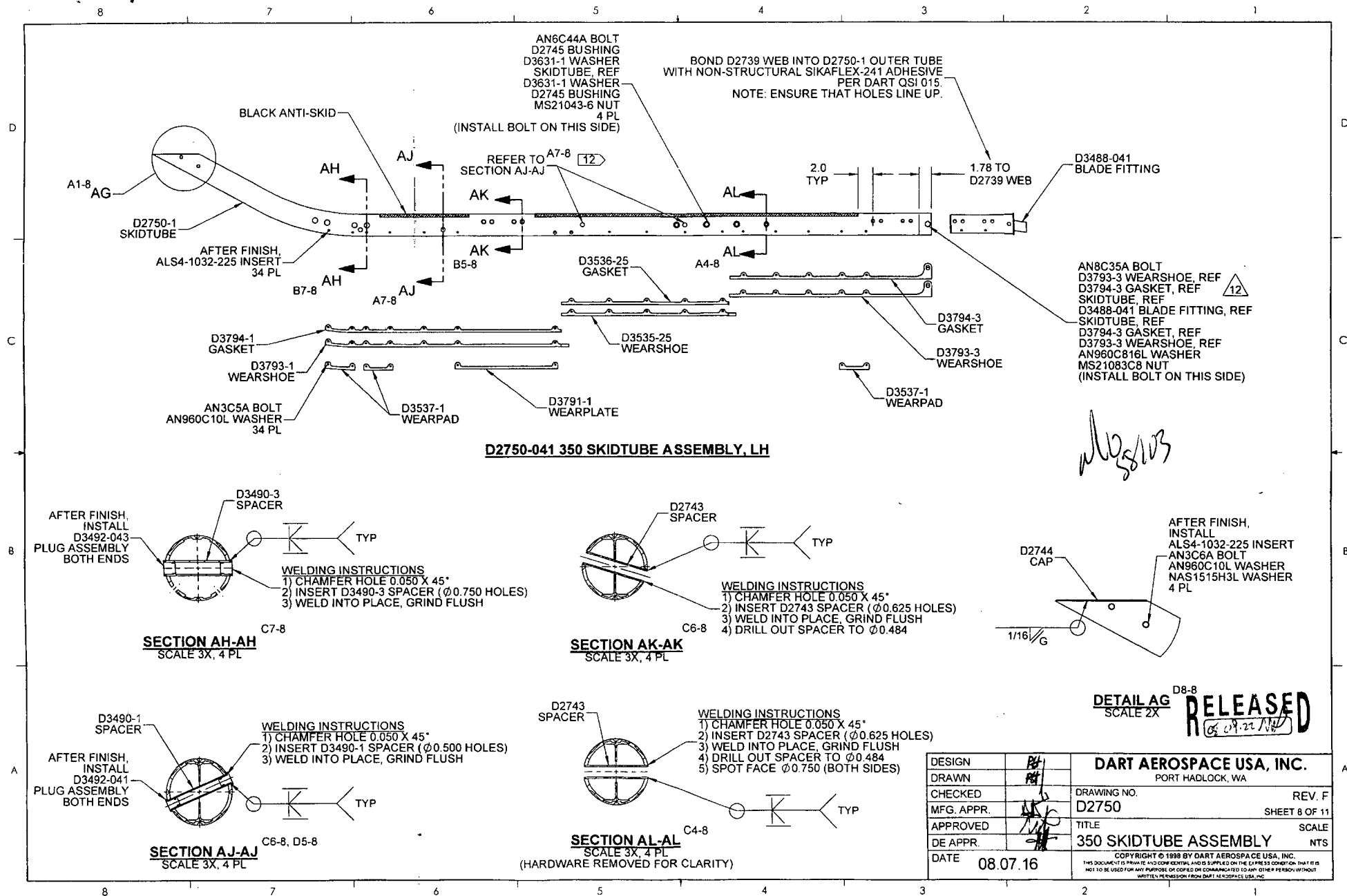


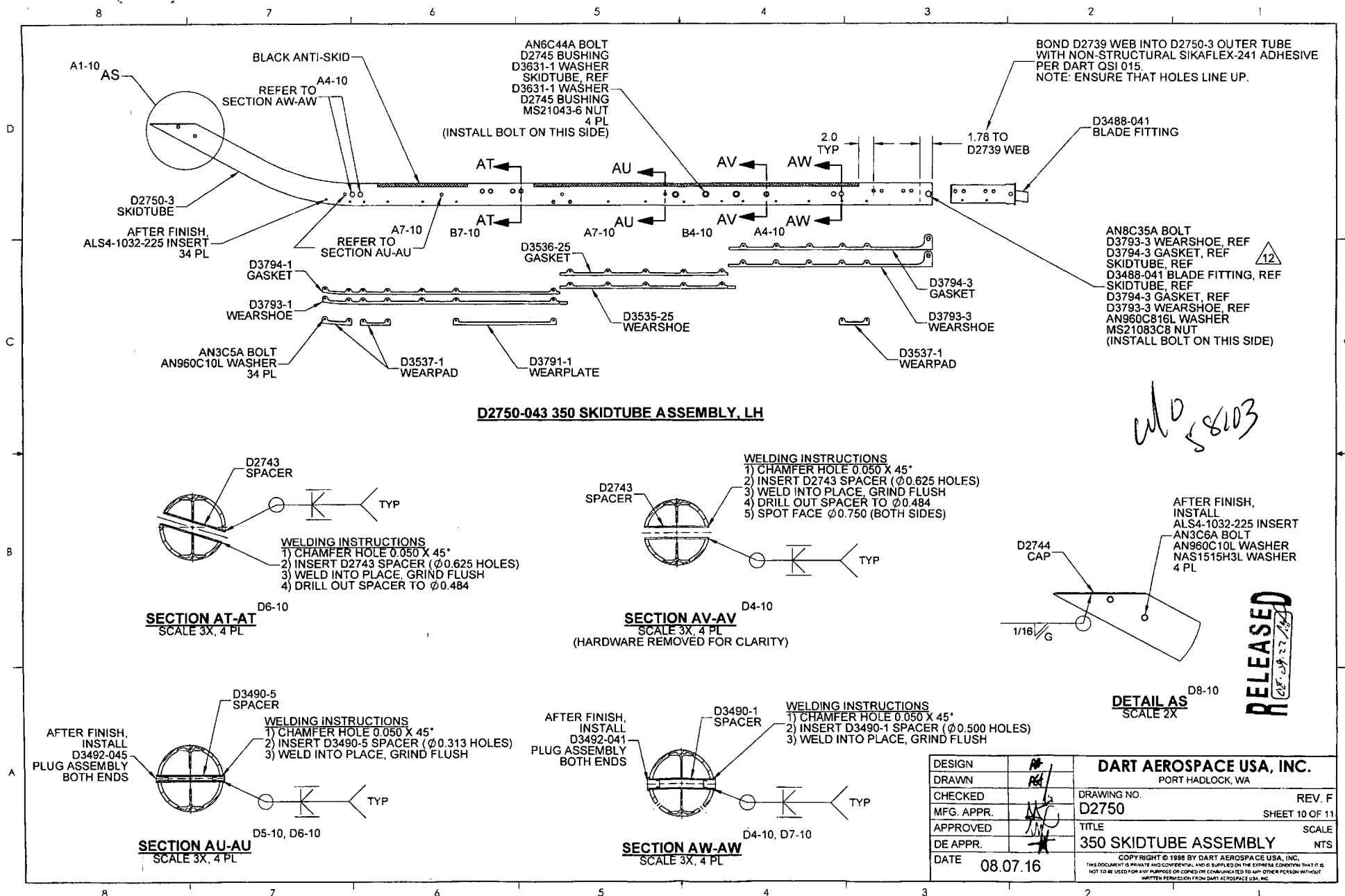
**SECTION AF-AF**  
SCALE 3X, 4 PL

*WLO 58103*

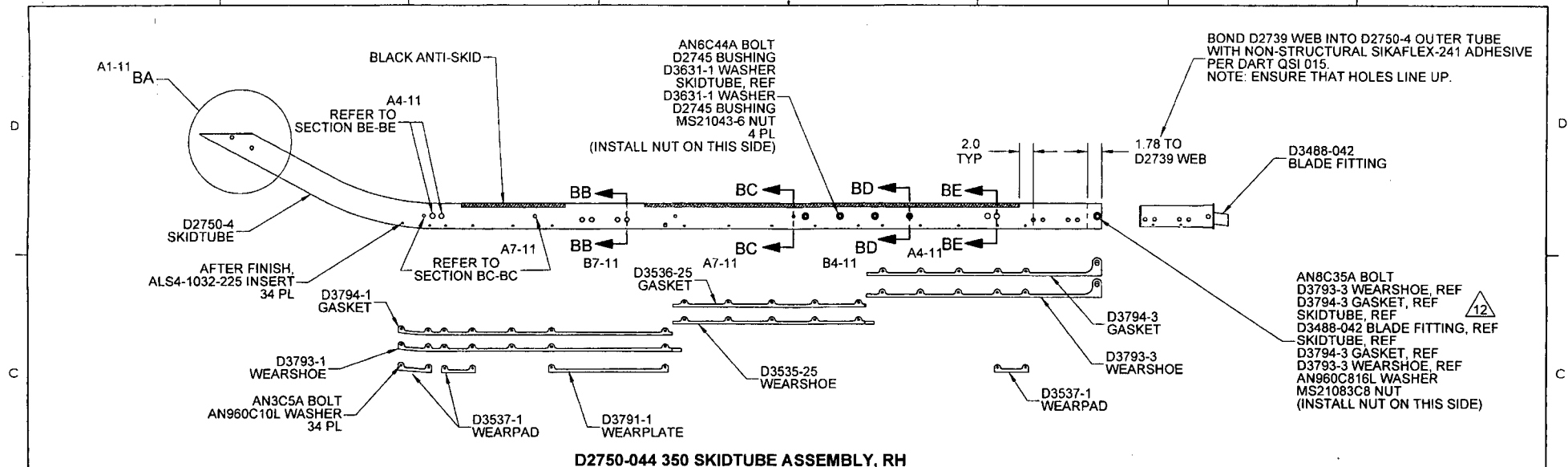
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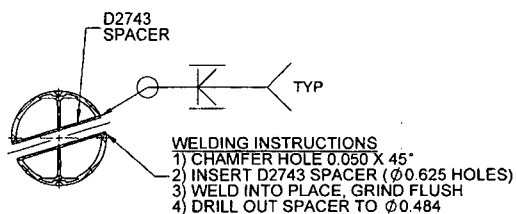




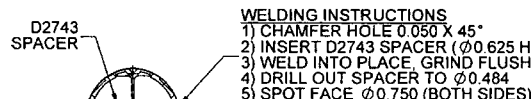
8 7 6 5 4 3 2 1



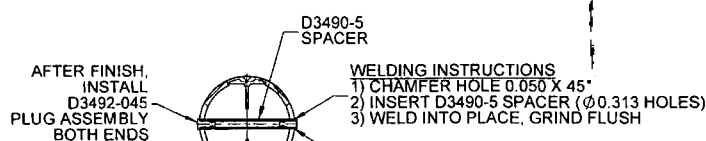
**D2750-044 350 SKIDTUBE ASSEMBLY, RH**



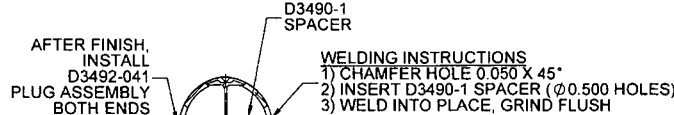
**SECTION BB-BB**  
SCALE 3X, 4 PL



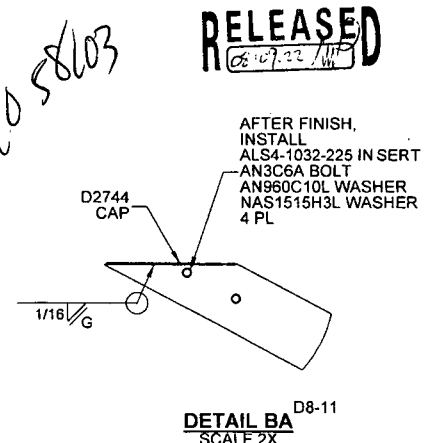
**SECTION BD-BD**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**SECTION BC-BC**  
SCALE 3X, 4 PL



**SECTION BE-BE**  
SCALE 3X, 4 PL



**DETAIL BA**  
SCALE 2X

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08.07.22 / 11/17

*WLO 58603*

NO. 229

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 581029  
Part number: D350 636 02  
Description: 350 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier P. D. J. Date of Test Coupon 10.04.27

Welder Barclay Elliott Date of Test Coupon 10-04-27

The above named individual is qualified in accordance with AWS D17.1.2001 to weld